












Dart Aerospace Ltd.Date: Tuesday, 22/04/2008 12:36:20 PM
User: Linda Lacelle*Eagle 4/044401***Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL REFERENCE DOOR ASSEMBLY
Job Number	: 37384	Part Number	: D412711011
Estimate Number	: 10902	Drawing Number	: N/A
P.O. Number	:	Project Number	: N/A
This Issue	: 22/04/2008 S.O. No. :	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: 12/02/2008 Type : PURCHASED PARTS	Due Date	: 28/02/2008 Qty: 1 Um: Each
Previous Run	: 37383		
Written By	: <i>W</i>		
Checked & Approved By	:		
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001			
2.0	PG	PURCHASING	
			
Comment: PURCHASING Issue P/O: <i>5685</i> to Eagle Copters "Assembly of D412-711-011 Door Send a copy of this IPP			
3.0	D412711041	Vertical Reference Door Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Vertical Ref. Door Assy			
4.0	D412711101	Replacement Bubble Window	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)			
5.0	D412711111	Wiring Harness, 212/412	
			
Comment: Qty.: 1.0000 Eagle(s)/Unit Total: 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412 <i>4/044500</i> <i>Apr 21/08</i>			

Page 1

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

w/ 44499

APR 21/08

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

w/ 44401

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 08-001222

1 EA20469-03 Rubber Strip

06-011664

1 EA20469-06 Aluminum Strip Deleted

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

1 EA20469-12 Fwd Rib

1 EA20469-13 Window

1 EA20469-14 Window Retainer

1 CA20469-16 Armrest Assy

1 EA20469-17 Angle

1 EA20469-18 Door Inner Skin

1 EA20469-21 Door Cover Panel

2 EA20469-23 Link

1 EA20469-24 Rod

1 EA20469-25 Arm Assy

w/ 44499

Material Certification / Proof of Traceability / Certificate of Conformity required

Date: Tuesday, 22/04/2008 12:36:20 PM
 User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		07-018796
22	AN3-4ABolt		08-001209
24	AN3-7ABolt		07-017476
6	AN960-6L Washer		06-022623
90	AN960-10L Washer		06-018522
34	CR3242-4-2 Rivet		08-001645
135	MS20426AD3-3 Rivet		07-006985
140	MS20426AD4-3 Rivet		05-002460
25	MS20470AD3-3 Rivet		07-007189
90	MS20470AD4-3 Rivet		07-015056
24	MS21042L3 Nut		08-002039
2	MS21042L06 Nut		06-014775
13	MS21069L3 Nut Plate		08-001202
8	MS21069L08 Nut Plate		07-018940
1	MS21071L3 Nut Plate		08-002216
1	MS21071L08 Nut Plate		08-001935
9	MS21075L3 Nut Plate		05-004764
2	MS24677-12 Screw		05-011931
6	MS27039-1-09 Screw		07-14232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install
 EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS
 Send this W/O back to DartKit to be stocked at Eagle

AS.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS.

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

AS. Not Required - delivered to H/C.

Form: rprocess

Date: Tuesday, 22/04/2008 12:36:20 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 37384

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doyle/29

Job Completion



EAGLE COPTERS MAINTENANCE LTD.

823 McTAVISH ROAD N.E. CALGARY ALBERTA T2E 7G9

DOI APPROVAL NO. 6-81

Nonmature

Manufacturer

Part No. 204-030-853-125 Serial No.

Total time

T.S.O.

Inspected

Previous Certification

Tested

Repair

Modification

Work Order

Overhaul

NEW

Removal

The maintenance described has been performed in accordance with the applicable standards of airworthiness

Eagle 37

NAME OF AUTHORIZED INSPECTOR

LC No. / Stamp

Details of outstanding work and other information on reverse

DATE

MAINTENANCE RELEASE

REMARKS

(Details of work performed/reason for removal)

Modified as per STC SH 92-55

(Additional work to be performed upon installation)

INSTALLED ON

DATE

0412-711-041
B/N 37384

Eagle Copters Maintenance Ltd

WORK REPORT

Work Order Number: 44255

V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1

Discrepancy:

Modify to Vertical Reference Door

Resolution:

Modified Door to Vertical Reference Door as per STC No. SH92-55 on Service order P/O 07-003317. Door assembled as required.

1.1 Work Done By: Robbie Neyrinck

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81

Signature: Colin Gould on 4/22/2008

Parts:

Part Number	Description	Lot Number	Condition	Qty
BELL212-L	BUBBLE WINDOW ILO EA20469-03 and D412-711-101	LT-08-001222	New	1

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

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This Issue	: 22/04/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: 12/02/2008	Project Number	: N/A
Previous Run	: 36802	Drawing Revision	: N/A
		Material	: N/A
		Due Date	: 28/02/2008
Written By	: <u> </u>	Qty:	1
Checked & Approved By	: <u> </u>	Um:	Each
Comment	: Est Rev:A 04.08.18 New Issue KJ/DS		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 5685 to Eagle Copters

C 208/021120

"Assembly of D412-711-011 Door

Send a copy of this IPP

3.0

D412711041

Vertical Reference Door Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0

D412711101

Replacement Bubble Window



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0

D412711111

Wiring Harness, 212/412



Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

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Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	EA2046915412	Instrument Panel, 412
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

7.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

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D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	EB212-100L / EA20469-3	Window	
---	------------------------	--------	--

1	EA20469-05	Rubber Strip	
---	------------	--------------	--

1	EA20469-06	Aluminum Strip	
---	------------	----------------	--

1	EA20469-07	Angle	
---	------------	-------	--

1	EA20469-08	Placard	
---	------------	---------	--

1	EA20469-10	Rear Rib Assy	
---	------------	---------------	--

1	EA20469-11	Angle	
---	------------	-------	--

1	EA20469-12	Fwd Rib	
---	------------	---------	--

1	EA20469-13	Window	
---	------------	--------	--

1	EA20469-14	Window Retainer	
---	------------	-----------------	--

1	EA20469-16	Armrest Assy	
---	------------	--------------	--

1	EA20469-17	Angle	
---	------------	-------	--

1	EA20469-18	Door Inner Skin	
---	------------	-----------------	--

1	EA20469-21	Door Cover Panel	
---	------------	------------------	--

2	EA20469-23	Link	
---	------------	------	--

1	EA20469-24	Rod	
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1	EA20469-25	Arm Assy	
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Qty Part Number Description Batch

14 AN3-3ABolt _____

22 AN3-4ABolt _____

24 AN3-7ABolt _____

6 AN960-6L Washer _____

90 AN960-10L Washer _____

34 CR3242-4-2 Rivet _____

135MS20426AD3-3 Rivet _____

140MS20426AD4-3 Rivet _____

25 MS20470AD3-3 Rivet _____

90 MS20470AD4-3 Rivet _____

24 MS21042L3 Nut _____

2 MS21042L06 Nut _____

13 MS21069L3 Nut Plate _____

8 MS21069L08 Nut Plate _____

1 MS21071L3 Nut Plate _____

1 MS21071L08 Nut Plate _____

9 MS21075L3 Nut Plate _____

2 MS24677-12 Screw _____

6 MS27039-1-09 Screw _____

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Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

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Job Number: 37383

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

